Date: User: Wednesday, 3/14/2007 3:30:19 PM

Kim Johnston

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** 

: 31219 : 11965

P.O. Number

: N/A

This Issue

: 3/14/2007

Prsht Rev.

: NC

First Issue **Previous Run** 

: NIA

: 3/14/2007

Type

S.O. No. : NIA

: RMA

**Part Number** 

**Drawing Name** 

**Drawing Number** 

: D2054 . D2054 REV B

**Project Number** 

: N/A **Drawing Revision** 

Material

: NIA

**Due Date** 

: 3/26/2007

: BUSHING

Qty:

100 Um:

Each

Written By Checked & Approved By

Comment

: Est A1 03:01.21 Revise Dwg Rev B; added Black Teflon or

Delring: Made on Cobra RF

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

**Description:** 

1.0

MDELRINR1000

Delrin Round Bar 1"

Comment: Qty.:

0.0612 f(s)/Unit Total:

6.1215 f(s)

Delrin Round Bar 1"

Matl:Black UHMW 1" dia or black Teflon or Black Delrin

103164

HARDINGE 2.0

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA

Deburr

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

3.0

QC8

QC2

SECOND CHECK



Comment: SECOND CHECK

PACKAGING RESOURCE #1



5.0 PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

## **Dart Aerospace Ltd**

| W/O:         |      | WORK ORDER CHANGES       | ER CHANGES |       |      |                                     |                          |
|--------------|------|--------------------------|------------|-------|------|-------------------------------------|--------------------------|
| DATE         | STEP | PROCEDURE CHANGE         | Ву         | Date  | Qty  | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|              |      |                          |            | 4-    |      |                                     |                          |
|              |      |                          |            |       |      |                                     |                          |
|              |      |                          |            |       |      |                                     |                          |
| <del>-</del> |      |                          |            |       |      |                                     |                          |
| Part No      |      | PAR #: Fault Category: N | CR: Yes    | No DQ | A: 🗐 | Date:⊘                              | 1/04/11                  |

QA: N/C Closed:

Date:

| NCR: |      |                   | WORK ORD             | ER NON-CONFORMANC            | E (NCR)        |                           |                       |                          |  |  |  |  |  |
|------|------|-------------------|----------------------|------------------------------|----------------|---------------------------|-----------------------|--------------------------|--|--|--|--|--|
|      |      | Description of NC |                      | Corrective Action Section B  |                | Varification              | A                     |                          |  |  |  |  |  |
| DATE | STEP | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |  |  |  |  |  |
|      |      |                   |                      |                              |                | 8                         |                       |                          |  |  |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |  |  |
|      |      |                   |                      |                              |                |                           |                       | 131                      |  |  |  |  |  |
| -    |      |                   |                      |                              |                |                           | 100 6 11 11 11        |                          |  |  |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |  |  |
| 7    |      |                   |                      |                              |                |                           |                       |                          |  |  |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |  |  |
|      |      |                   |                      |                              |                |                           |                       |                          |  |  |  |  |  |

NOTE: Date & initial all entries

Date:

Wednesday, 3/14/2007 3:30:19 PM

User: Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 31219

Part Number: D2054

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M A. M. 12

| Dart Aerospace L | _td |
|------------------|-----|
|------------------|-----|

| Dart Ae | rospace | e Ltd             |                        |           |        |                 |                                     |                          |
|---------|---------|-------------------|------------------------|-----------|--------|-----------------|-------------------------------------|--------------------------|
| W/O:    |         |                   | WORK ORDER CH          | ANGES     |        |                 | - 12                                |                          |
| DATE    | STEP    | PRO               | OCEDURE CHANGE         |           | Ву     | Date Qty        | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|         |         |                   |                        |           |        |                 |                                     |                          |
|         |         |                   |                        |           |        |                 |                                     | ·                        |
| Part No | :       | PAR #:            | Fault Category:        |           |        | lo <b>DQA</b> : |                                     |                          |
| NCR:    |         |                   | WORK ORDER NON-CONFO   |           |        |                 |                                     | 1                        |
|         |         | Description of NC | Corrective Action      | Section B |        | Verification    | A                                   |                          |
| DATE    | STEP    | Section A         | Initial Action Descrip | tion      | Sign & | Section C       | Approval<br>Chief Eng               | Approval<br>QC Inspector |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                              |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|------------------------------|----------------|---------------------------|-----------------------|--------------------------|
|      |      | Description of NC                |                      | Corrective Action Section B  |                |                           |                       |                          |
| DATE | STEP | Section A                        | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      | ,                                |                      |                              |                |                           |                       |                          |
|      |      | Ç.                               |                      |                              |                |                           |                       |                          |
|      |      |                                  |                      | <b>(</b> )                   |                |                           |                       |                          |
| ÷    |      |                                  |                      |                              |                |                           |                       |                          |
|      |      |                                  |                      |                              |                |                           |                       | × -                      |
|      | ·    |                                  |                      |                              |                |                           |                       |                          |
|      |      |                                  |                      |                              |                |                           |                       |                          |
|      |      |                                  |                      |                              |                |                           |                       |                          |
|      |      |                                  |                      |                              |                |                           |                       |                          |

NOTE: Date & initial all entries

| DART AEROSPACE LTD           | Work Order:  | 31219       |
|------------------------------|--------------|-------------|
| Description: Bushing         | Part Number: | D2054       |
| Inspection Dwg: D2054 Rev: B |              | Page 1 of 1 |

| pection Dwg          | : D2054 Rev.  | <u> </u>            |           |        |                      | Fay    | e i oi |
|----------------------|---------------|---------------------|-----------|--------|----------------------|--------|--------|
|                      | FIRST         | ARTICLE IN          | ISPECTION | ON CHE | CKLIST               |        |        |
|                      | X             | 7                   |           | _      | otype                |        |        |
| Drawing<br>Dimension | Tolerance     | Actual<br>Dimension | Accept    | Reject | Method of Inspection | Com    | ments  |
| Ø1.00                | +/-0.030      | 1.002               |           |        |                      |        |        |
| 0.063                | +/-0.010      | ·XeH                |           |        |                      |        |        |
| 0.500                | +/-0.010      | .499                | /         |        |                      |        | _      |
| 0.03 x 45°           | +/-0.030      | ,03x4sc             |           |        |                      |        |        |
| R0.016               | +/-0.010      | r.016               |           |        |                      |        |        |
| Ø0.625               | +0.005/-0.000 | 624                 | 1         |        |                      |        |        |
| Ø0.510               | +0.005/-0.000 | .515                |           |        |                      |        |        |
|                      |               |                     |           |        |                      |        |        |
|                      |               |                     |           |        |                      |        |        |
|                      |               |                     |           |        |                      |        | -      |
|                      |               |                     |           |        |                      |        | ****   |
| 1100 may 2 17 1 m    |               |                     |           |        |                      |        | -      |
|                      |               |                     |           |        |                      |        |        |
|                      |               | -                   |           |        |                      |        |        |
|                      |               |                     |           |        |                      |        |        |
|                      |               |                     |           |        |                      |        |        |
|                      |               |                     |           |        |                      |        |        |
|                      |               |                     |           |        |                      |        |        |
|                      |               |                     |           |        |                      |        |        |
|                      |               |                     |           |        |                      |        |        |
|                      |               |                     |           |        |                      |        |        |
|                      |               |                     |           |        |                      |        |        |
|                      |               |                     |           |        |                      |        |        |
|                      | T. lek        |                     | > > 0     |        |                      |        |        |
| easured by:          | 2779 L        | Audited by:         | MS        |        | Prototype Appro      |        | N/A    |
| Data                 | 20111100      | Data                | 2-1-1     | _ 1 1  | r                    | Jata · | NI/A   |

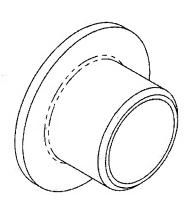
| Measured by: 5 1/5/5 | Audited by: | MS       | Prototype Approval: | N/A |
|----------------------|-------------|----------|---------------------|-----|
| Date: 07/04/06       | Date:       | 07/04/05 | Date:               | N/A |

| Rev | Date     | Change    | Revised by | Approv#d |
|-----|----------|-----------|------------|----------|
| Α   | 04.06.10 | New Issue | KJ/JLM     |          |
|     |          |           |            |          |

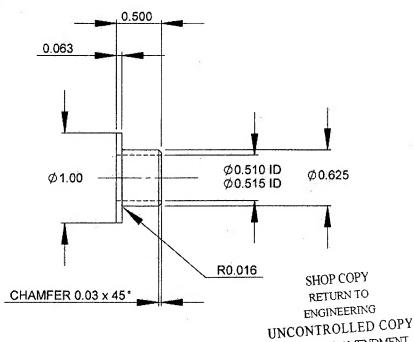


| DESIGN DRAWN BY |          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |  |  |  |
|-----------------|----------|---|------------------------|--|--|--|
| CHECKED         | APPROVED | D2054   | REV. B<br>SHEET 1 OF 1 |  |  |  |
| DATE 01.12.20   |          | BUSHING   | SCALE<br>1:1           |  |  |  |
|                 | 92.05.13 | NEW ISSUE   |                        |  |  |  |
| Α               | 01.06.05 | CHANGE TOL. ON ID.                                |                        |  |  |  |
| В               | 01.12.20 | REDRAW; ADD DELRIN OP                             | TION; ADD NOTES        |  |  |  |





## **ISOMETRIC DETAIL (SCALE 2:1)**



SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

## **D2054 BUSHING**

MATERIAL: BLACK TEFLON or BLACK UHMW or BLACK DELRIN

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

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